

Date: Thursday, 3/30/2006 10:06:29 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REPLACEMENT WINDOW ASSEMBLY
Job Number	: 26454		
Estimate Number	: 11174		
P.O. Number	: NIA	Part Number	: D3290041
This Issue	: 3/30/2006	S.O. No.	: NIA
Prsht Rev.	: NC	Drawing Number	: D3290 REV A
First Issue	: NIA	Project Number	: N/A
Previous Run	: NIA	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	: NIA
Written By	: SEE COMMENT BELOW	Due Date	: 4/10/2006
Checked & Approved By	: <u>JA 06.03.30</u>	Qty:	8 Um: Each
Comment	: Est. B 05.05.25 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING
Issue P/O: 00000928 AP 06/04/03
Manufacture D3290-1 as per Dwg D3290
Possible Supplier: GFI
Material release note is required

2.0	D32901F	Window Frame
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Comment: Qty.: 1.0000 U(s)/Unit Total : 8.0000 U(s)
Replacement Window Assy

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

NIA
R

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Mel. F.

06.04.27

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06-04-28

(8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 D2126 Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 52.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description Batch

1 D2126-0780 Locking Seal *B 2570-2* ✓

10.0 D32901 Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description Batch

1 D3290-1 Window Frame *B26454* ✓

11.0 D32903 Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Window

Pick:

Qty Part Number Description Batch

1 D3290-3 Window *B26461* ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 20.05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 26454

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

540 06:08:02 6

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST106

06/05/03 6

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/04 6

Job Completion



06/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

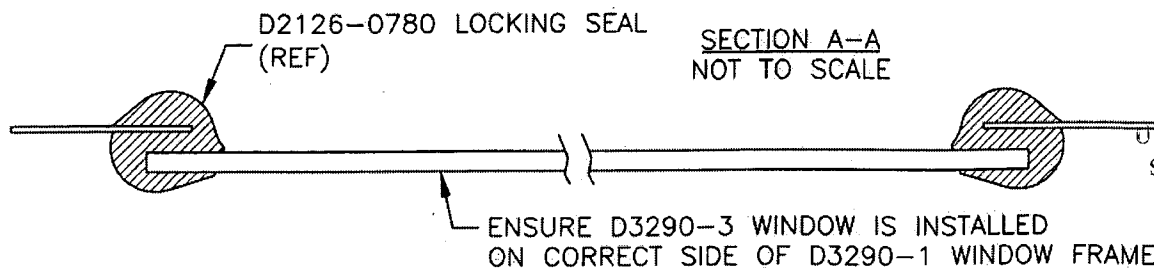
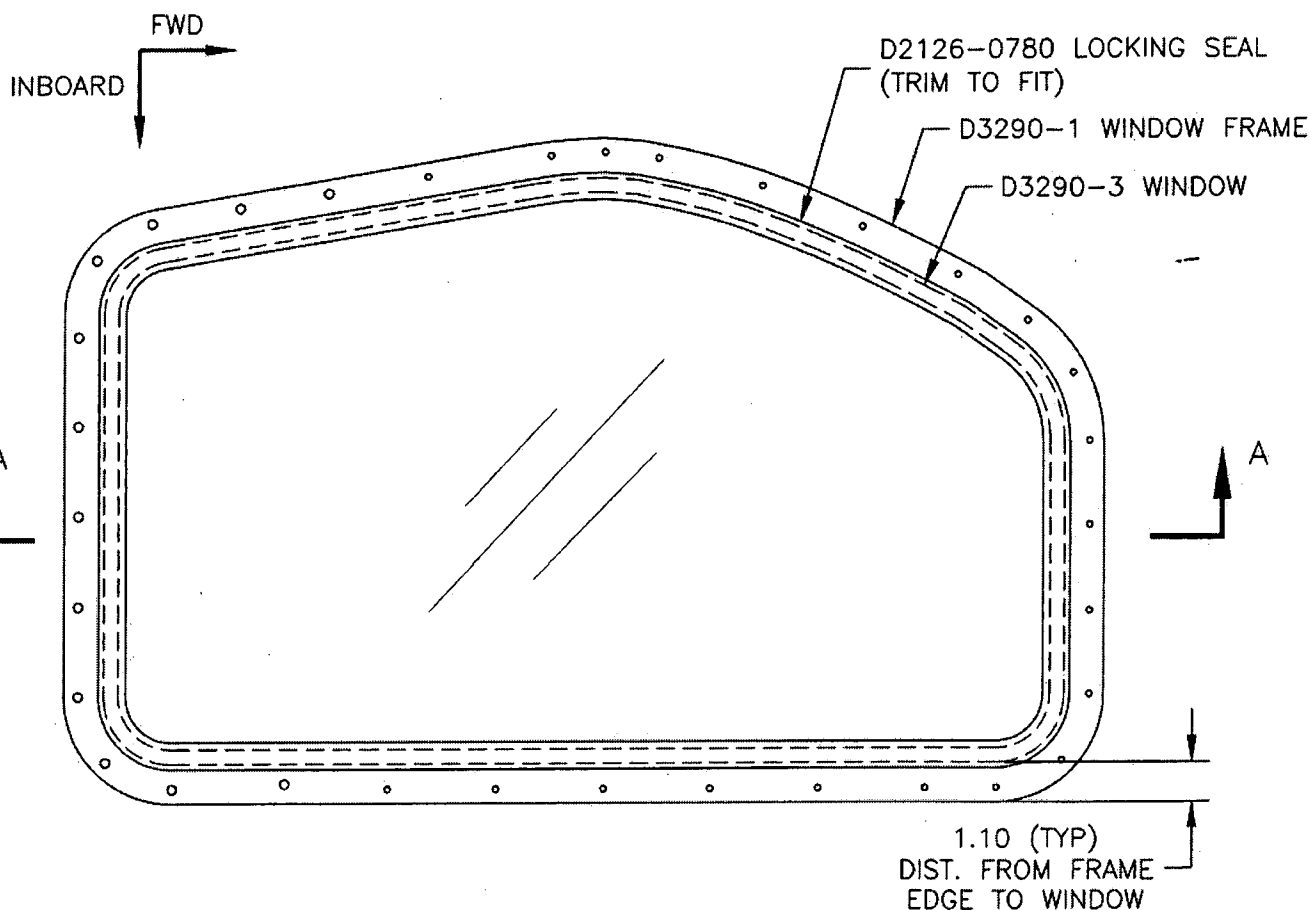
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3290	REV. A SHEET 1 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
A	04.06.14	NEW ISSUE	



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WITHOUT NOTICE
WORK ORDER
NO. 26454

D3290-041

RELEASED
04.07.12

NOTES

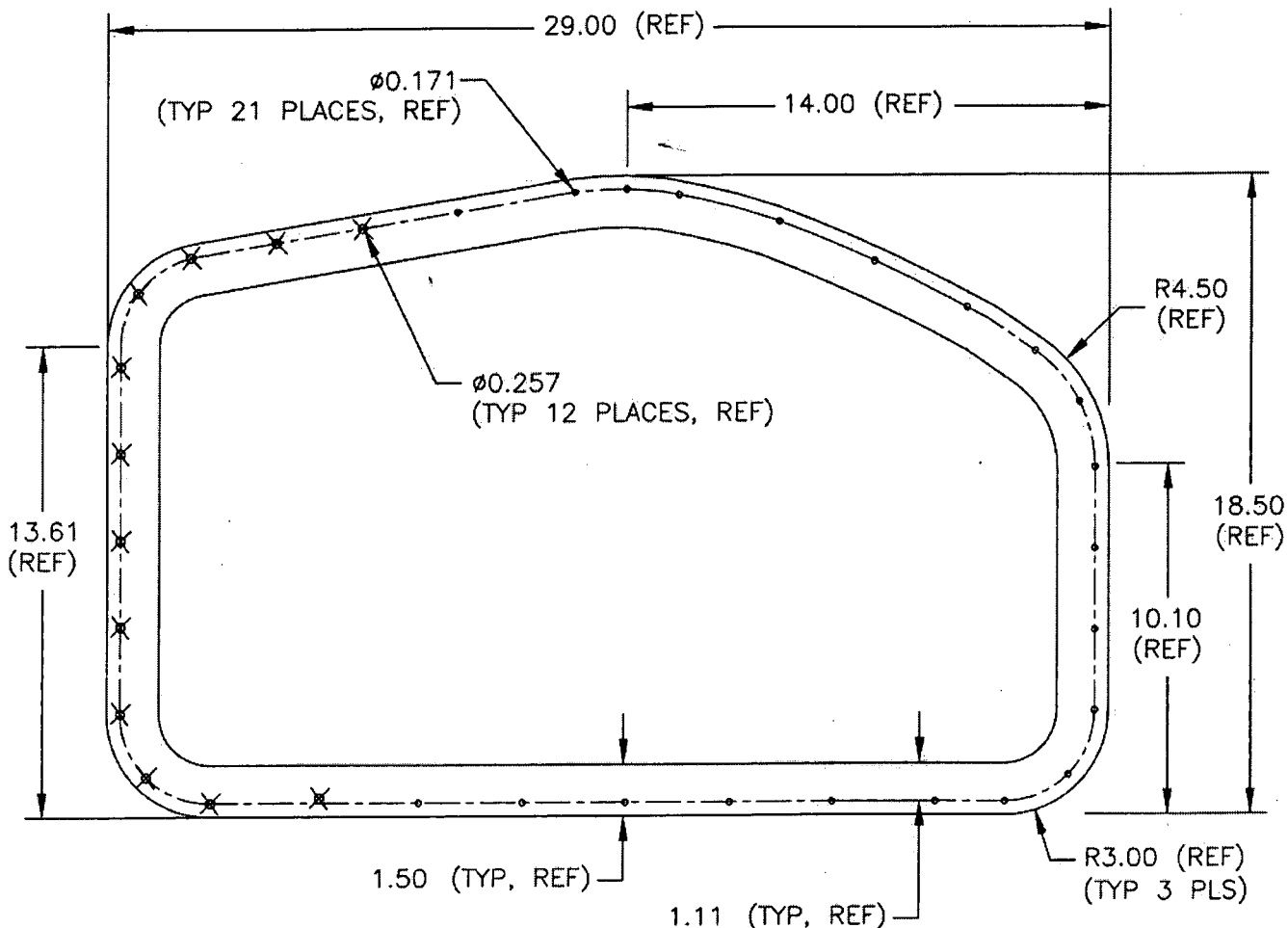
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3290	REV. A SHEET 2 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5

**D3290-1 FRAME****D3290-1**

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.14

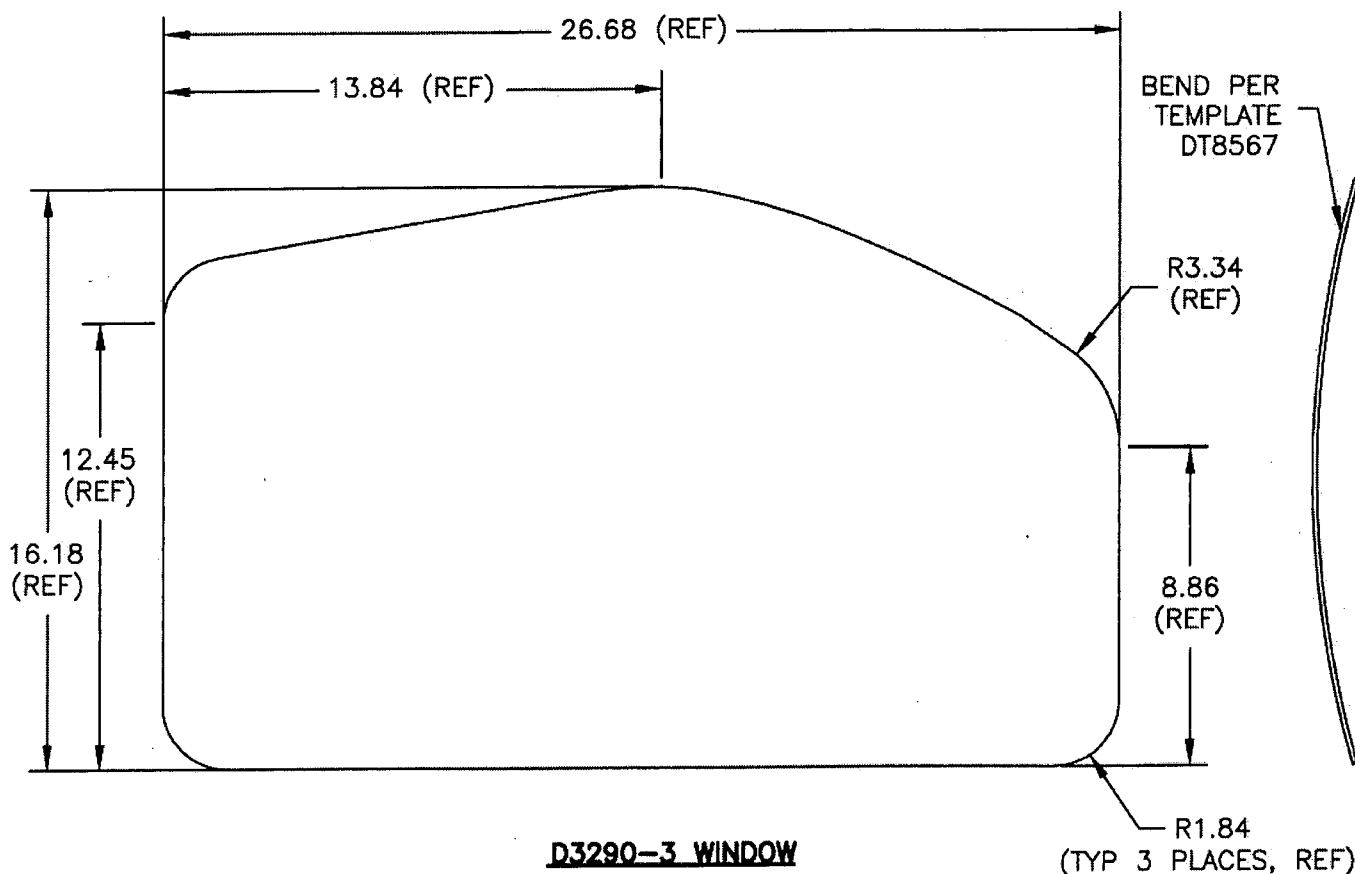
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3290	REV. A SHEET 3 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



D3290-3

- 1) MATERIAL: M-ACRYLIC-S.125 (1/8" ACRYLIC SHEET)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

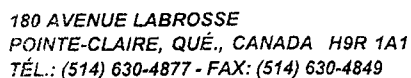
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WORK ORDER
26454

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VENDU À / SOLD TO



DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2006/04/20	0335452

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.		N° COMMANDE PO NO.		VIA SHIP VIA.	
DART GFI-0299		J0141579		PO00000928			
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.			DESCRIPTION			
8	D3290-1			FRAME CERTIFICATE OF CONFORMANCE REQ			

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECUPAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>3</u>		OUR JOB NO. <u>J0141579</u>		SHIPPING MEMO <u>0335452</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
	<u>8 PCS</u>	<u>PO00000928</u>	<u>D3290-1</u>		<u>FRAME</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>AL 5052-H32</u>		<u>SAMUEL SPECIALTY</u>		<u>0058953 ATT'D</u>	
	PROCESS		PROCESSOR	RELEASE NOTE #	
1	<u>.040</u>				
2					
3					
4					
5					
6					
7					
8					
9					

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 21 APRIL 2006

G.F.I. Q.C. REP.

Patton H. Smith


LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: 20 JUIN 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058953
Customer's order #:

de commande SSMQ: 842342
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
4	9	.040" X 48" X 96"	5052 H32		1388651

Bien à vous,
Yours truly,

Joël Raymond

Commis à l'administration.
Administration Clerk.



LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE COM 12/01/04

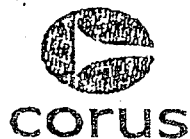
DOC : V/0080134390

DATE : 2004-11-19

PROD. REF. : 0000166327

NR : 50914/01

PAGE : 1 / 1



INSPECTION CERTIFICATE

CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400
SCHAUMBURG 60173 USAYOUR ORDER NUMBER : P02731 (SAMOVL'S PO# A15790)
OUR ORDER NUMBER : 50914/01
DOCUMENT NUMBER : V/0080134390Corus Aluminium NV.
A. Staelen 87, 2510 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94DESCRIPTION : ALU SHEET 5052-H32 QQA-250/8 AMS 4016 ASTM B209
DIMENSIONS : 96" X 48" X 0.04"
ARTICLE NO. :COIL
NUMBERCAST
NUMBER

CHEMICAL COMPOSITION (%)

		SI	FE	CU	MN	MG	CR	ZN
	MIN					2,2	0,15	
	MAX	0,25	0,40	0,10	0,10	2,8	0,35	0,10
002	1388651	0,12	0,26	0,01	0,09	2,5	0,16	0,01

OTHERS : EACH : MIN 0,05 MAX
TOTAL : MIN 0,15 MAXTEST-
NUMBER

MECHANICAL PROPERTIES

1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI

/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

		RM KSI	RP02 KSI	A %
	MIN	31	23	5
	MAX	38		
002	/M	33	29	10

D) 282443

444

445

HEAD OF LABORATORY,
XAVIER SCHELTJENS

